



Repair

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.4001

Job Sheet 190698



Part No: 646.4001

Job Qty: 1 pcs

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/13/19

Job Tracking No:

Due Date: 3/29/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		MAR 07 2019
					Setup	Run	Workcenter / Supplier	Lead Time	
					Hrs	Hrs			Sign-off
110	Packaging 1 - Pick Kit	1 pcs	3/29/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		MAR 21 2019
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S164956



Part: 646.4001

Job No: 190698

Serial No/Batch: S164956

Revision:

Inspector:

Exp Date: 08/18/2019

Instructions: FAA STC SR02180LA 14/08/07 T4 STC SH09 -

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120 QC 4	1 pcs	3/29/19	0.00 0.00		QC 4 - 26	
					QC 4 - 28	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
130 Packaging 3-1 - Stock - B4B	1 pcs	3/29/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	1 pcs	3/29/19	0.00 0.00		DC - 1 - B4B	
					DC - 2 - B4B	
140 QC 21 - FG	1 pcs	3/29/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - FG - 53	

Part Op 110 - pick kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

130 - Identify and pack for shipping as per PPP 646.4001 Location: _____

135 - Document Control - Photocopy bluefile & type labels per PPP 646.4001

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	110-Packaging 1 - Pick Kit	5019004
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5139403
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5139402
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5157376
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5136734
646.2910	Deflector	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5093821
646.3001	Lower Cable Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5159178
646.3110	Channel	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5154342
646.3210	Support	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5131202
646.3301	Upper Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5159082
646.3510	Strut	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5127740
646.3511	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5127662
646.3610	Filler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5131480
646.3710	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5059684
646.3711	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5158065
646.3712	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5128050
646.3713	Gusset	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5124418
646.3714	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5145099
646.3715	Strut Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5139095
646.3716	Gauge Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5063780
646.3717	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5082377
646.3718	Custom Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5145123
646.3719	Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5143744
646.3810	Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5150081
646.3811	Radius Block	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5070843
646.3812	Gusset Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5150415
646.3813	AS350 Strut Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5131319
646.3910	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5128166
646.3911	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5133609
646.3912	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5124372
646.3913	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5044498
646.9410	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5056998
647.0112	Strut Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5133711
647.7703	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5143339
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5131245
AN3-11A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5157480
AN3-12A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5133162
AN3-13A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5098032
AN3-3A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5131193
AN3-4A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5149128
AN3-5A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5149158
AN3-6A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5103950
AN316C4R	Nut, Jam	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5130135
AN44-5A	Eyebolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5156948
AN4C7A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5071343
AN665-34R	Clevis	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5142147
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	110-Packaging 1 - Pick Kit	5133184
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	110-Packaging 1 - Pick Kit	5130137
MS20426AD5-7	Rivet	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5153848
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	514134063
MS20470AD5-6	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5048697
MS20470AD5-7	Rivet	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5123425
MS21042L08	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5134219
MS21042L3	Nut	63 Ea (63 ea)	110-Packaging 1 - Pick Kit	5130347
MS21042L4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5149814
MS21047-3	Nut Plate	18 Ea (18 ea)	110-Packaging 1 - Pick Kit	5152823
MS24693-C278	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5065341
MS24694-S51	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5123459
MS24694-S54	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5152667

Exp 6/30
2019
Exp 09/19

Electron

5133009

MS24694-S55	Screw	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5099526
MS27039-08-13	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5123937
MS27039-1-10	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5148605
MS27039-1-12	Screw	6 Ea (6 ea)	110-Packaging 1 - Pick Kit	5124664
MS27039-1-16	Screw	24 Ea (24 ea)	110-Packaging 1 - Pick Kit	5104364X4 5140520X20
MS27039-1-19	Screw	22 Ea (22 ea)	110-Packaging 1 - Pick Kit	5155608
MS27039-1-20	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5090554
MS27039-1-21	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5104011
NAS1149F0332P	Washer	144 Ea (144 ea)	110-Packaging 1 - Pick Kit	5157648
NAS1149F0363P	Washer	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5075330
NAS1149F0432P	Washer	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5152652
NAS1149FN832P	Washer	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5143216

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0129	8	280	0
	600.0990	1	26	0
	600.0991	1	26	0
	600.1012	1	33	0
	600.1013	5	81	0
	646.2910	1	10	0
	646.3001	1	5	0
	646.3110	1	25	0
	646.3210	1	18	0
	646.3301	1	10	0
	646.3510	1	21	0
	646.3511	1	21	0
	646.3610	1	17	0
	646.3710	1	30	0
	646.3711	1	17	0
	646.3712	1	20	0
	646.3713	1	24	0
	646.3714	1	23	0
	646.3715	2	17	0
	646.3716	1	16	0
	646.3717	1	22	0
	646.3718	2	24	0
	646.3719	2	16	0
	646.3810	2	19	0
	646.3811	1	6	0
	646.3812	2	18	0
	646.3813	1	13	0
	646.3910	4	53	0
	646.3911	1	21	0
	646.3912	4	25	0
	646.3913	1	16	0
	646.9410	1	78	0
	647.0112	2	38	0
	647.7703	2	10	0
	650.9201	2	41	0
	AN3-11A	10	351	0
	AN3-12A	2	98	0
	AN3-13A	1	50	0
	AN3-3A	4	315	0
	AN3-4A	10	328	0
	AN3-5A	2	367	0
	AN3-6A	2	475	0
	AN316C4R	2	50	0
	AN44-5A	2	45	0
	AN4C7A	2	121	0
	AN665-34R	2	46	0
	CCR264SS3-02	36	1,063	0
	CR3213-5-3	14	259	0
	MS20426AD5-7	2	907	0
	MS20470AD5-5.5	8	985	0
	MS20470AD5-6	8	862	0
	MS20470AD5-7	3	85	0
	MS21042L08	2	1,898	0
	MS21042L3	63	4,022	0

MS21042L4	2	3,987	0
MS21047-3	18	363	0
MS24693-C278	5	141	0
MS24694-S51	5	227	0
MS24694-S54	2	169	0
MS24694-S55	3	188	0
MS27039-08-13	2	477	0
MS27039-1-10	2	531	0
MS27039-1-12	6	185	0
MS27039-1-16	24	1,280	0
MS27039-1-19	22	867	0
MS27039-1-20	2	78	0
MS27039-1-21	4	30	0
NAS1149F0332P	144	5,184	0
NAS1149F0363P	2	463	0
NAS1149F0432P	4	2,099	0
NAS1149FN832P	4	2,286	0

Part Specifications

Specifications could not be found.

Plex 3/5/19 12:51 PM Dart.Quirion.Sonia

NOTES:

- R

0.5304

D

				2		2	41	601.2829	SCREW	MS24694554
				2		2	40	601.2831	RIVET	MS20426ADS-7
				1		1	39	646.3716	GAUGE BRACKET	
				6		6	38	601.1953	SCREW	MS27039-1-12
			2			2	37	646.3715	STRUT DOUBLER	
		2		2		2	36	601.2824	BOLT	A19-5A
12		36				36	35	601.2277	RIVET	FC06455-3-00
6		18				18	34	600.0795	NUTPLATE	MS21047-3
3		3				3	33	601.2565	RIVET	MS20470ADS-9
1		1				1	32	646.3813	STRUT BRACKET	
4		4				4	31	601.2822	BOLT	A19-3A
2		2				2	30	646.3812	GUSSET BRACKET	
8		8				8	29	601.2564	RIVET	MS20470ADS-6
1		1				1	28	646.3714	GUSSET	
		1		1		1	27	646.3610	FILLER	
		3		3		3	26	601.2830	SCREW	MS24694555
		2		2		2	25	601.2825	BOLT	A19-5A
		1		1		1	24	646.3811	RADIUS BLOCK	
		1		1		1	23	646.3712	CLIP	
		1		1		1	22	646.3711	CLIP	
8		8				8	21	601.2832	RIVET	MS20470ADS-8.5
14		14				14	20	601.2020	RIVET	CR3213-5-3
4		6		6		10	19	601.2823	BOLT	A19-4A
		1		1		1	18	601.2827	BOLT	A19-13A
		5		5		5	17	601.2912	SCREW	MS24694251
1		1				1	16	646.3713	GUSSET	
1		1				1	15	646.3210	SUPPORT	
		1				1	14	646.3710	DOUBLER	
		1		1		1	13	646.3110	CHANNEL	
14	10	8	53	6	61	12		601.1624	LOCKNUT	MS2104213
16	32	18	120	16	144	11		601.1607	WASHER	NAS1149F0329
						10		646.3410	LH WIPER DEFLECTOR	
						9		646.3411	RH WIPER DEFLECTOR	
				2	2	8		647.7703	STRUT ASSY	
				2	2	7		647.0112	STRUT BRACKET	
		1		1		1	6	646.3511	STRUT	
		1		1		1	5	646.3510	STRUT	
2		2				2	4	646.3810	BRACKET	
				1		1	3	646.2910	DEFLECTOR	
		1		1		1	2	646.3001	LOWER CUTTER ASSY	
				1		1	1	646.3301	UPPER CUTTER ASSY	
X								646.4006	LOWER CUTTER TYPED PROVISIONS	
	X							646.4005	LOWER CUTTER REMOVABLE PROVISIONS	
		X						646.4004	FIXED PROVISIONS KIT	
			X					646.4003	CABLE CUTTERS KIT WITH/OUT FIVE PREVIDENTS	
				X				646.4002	ASS250 WIPER DEFLECTOR KIT	
					X			646.4001	ASS250 CABLE CUTTERS KIT	
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY		PARTS LIST	
NEXT ASSY (S)		ORIGINAL DATE INC/DAY/HR 02/07/08 INC/DAY/HR 02/07/08 DRAWING APPROVAL P. BRAYO 02/07/08 CONTRACT NO.	 9030 ENTERPRISE CT. SUITE 200 VISTA, CA 92081 (760) 724-5300 AEROSPACE INDUSTRIES INC DBS DART AEROSPACE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS FRACTIONS ANGLES 2 DECIMALS 1/1000		SIZE	REV
		B	C
		RZT 07A76	DWS: NO 646.4000
		SCALE NONE	SHEET OF 5